

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023295**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

Documentation review

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Fluor (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13CW. He has also verified the Non-Destructive Testing requirements for each weldment that includes the NDT process (UT, MT and RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

INCIDENT REPORT

Description of Incident: During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on OBG 13BE this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) longitudinal linear indication on the Longitudinal Diaphragm (LD3027) Weld 056, measuring approximately 4 mm in length.
- This indication is located on the Longitudinal Diaphragm (LD3027) Weld 056 Joining to the Hold-Back. Located between PP121.5 and PP121.
- The indication is clearly marked on the material near the weld.

The Notice of Witness Inspection Number (NWIT) is 08968 . The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

WELDING INSPECTION REPORT

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MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13BE. The welds designations reviewed are as follows: SEG3009B-20/21/22/23 , SEG30009d-017/020/021/022/023 , SEG3009F-016/017/161/162/164/165 , SEG3009H-016/017/161/162/164/165 , SEH3009K-179,180,181,182,183,184,185,186,187,188,189,190,199,200, 201,202,203,204,205,206,207,208,209,210 , LD3027-078~081,044,045,048~051,054,055,056,057,062,063,068, 069,072~075.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
